

Work Order ID 56860

March 11, 2010 10:10:15 AM



Page 1

Item ID: D3772-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Leg

Start Date: 11/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 22/03/2010 Req'd Qty: 6.00



Customer:

Reference:

10.03.11

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3772	Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 31.500" long

10/03/11

6 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA787 Rev: *AA* & Dwg D3772 Rev *AA*

10/03/11

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/03/11

6 0

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

MMR
02/03/15

6 *8*

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3772: 2- deburr: 13-bend tube as per dwg D3772

= 7m. L

6X
10/03/16

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

6

10/03/17

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Start Date: 11/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 22/03/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 254

0.00



Packaging

Memo

0.00

Packaging

PC 10/3/19 (6)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 JH

CZ 10/3/19

Picklist Print

March 11, 2010 10:10:14 AM

Page 1

Work Order ID: 56860



Parent Item: D3772-1



Parent Item Name: Back Leg

Start Date: 11/03/2010

Required Date: 22/03/2010

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-09-24 Now on Haas JLM Verified By:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304TR1.250W.125

Purchased

No

110

f

32.6750

16.5802



304 RD Tube 1.250 x .125w

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

32.675

110316

4.5

113494

28.175

L.F 10/03/11

16.5802
+ 19" scrap.

DART AEROSPACE LTD		Work Order:	528620
Description: Back Leg		Part Number:	D3772-1
Inspection Dwg: D3772 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

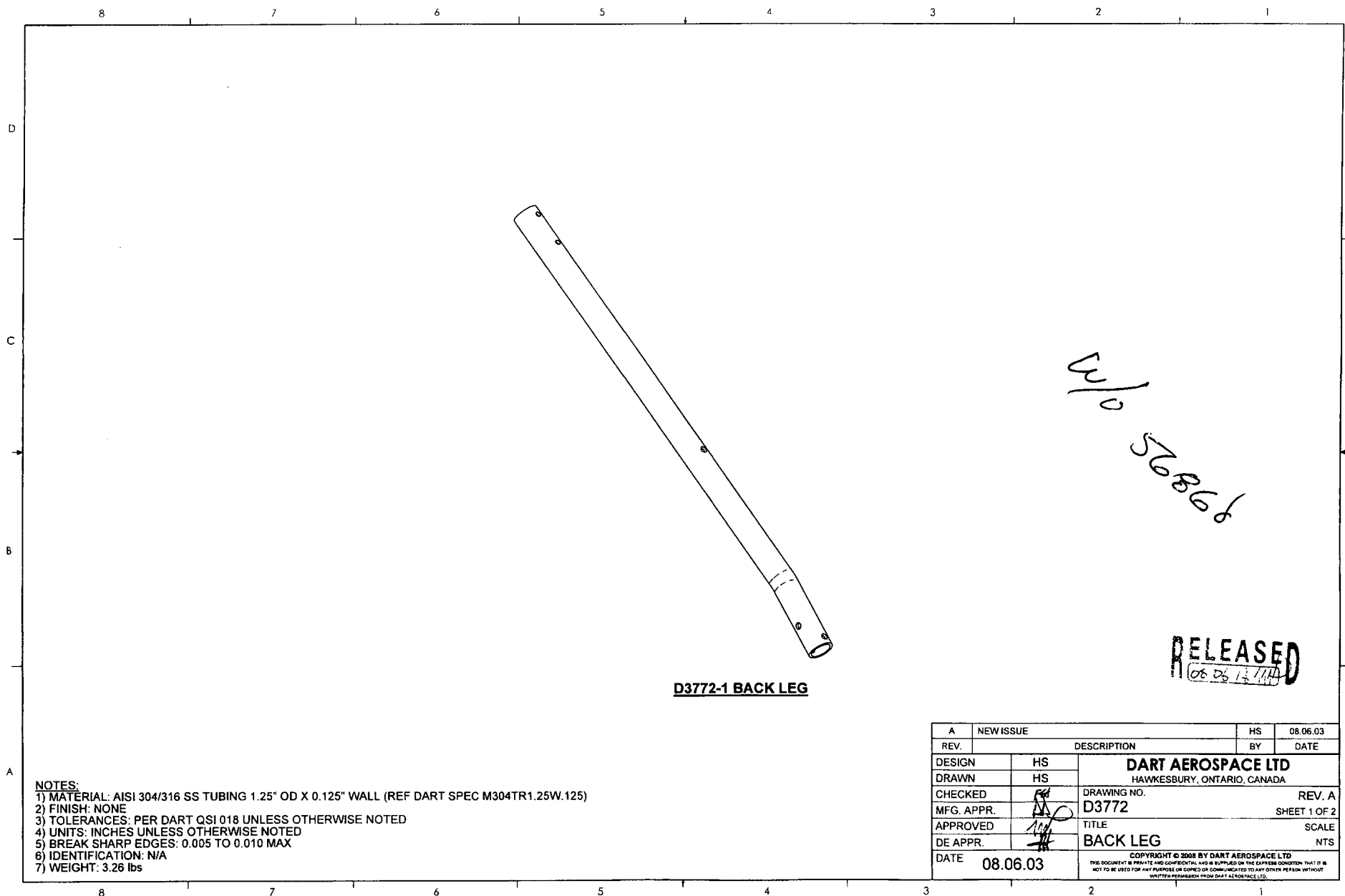
☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	.490	/			
1.70	+/-0.030	1.699	/			
Ø0.257	+0.006/-0.001	.260	/			
12.56	+/-0.030	12.56	/			
Ø0.323	+0.006/-0.001	.325	/			
0.61	+/-0.030					
Ø0.323	+0.006/-0.001	.325	/			
Ø1.250	+/-0.010	1.240	/			
0.125	+/-0.010	.115	/			
3.75	+/-0.030					
1.10	+/-0.030	1.098	/			
0.38	+/-0.030					
Ø0.323	+0.006/-0.001	.325	/			

Measured by: <i>B.F.</i> Date: <i>10/03/11</i>	Audited by: <i>MMR</i> Date: <i>10/03/16</i>	Prototype Approval: N/A Date: N/A
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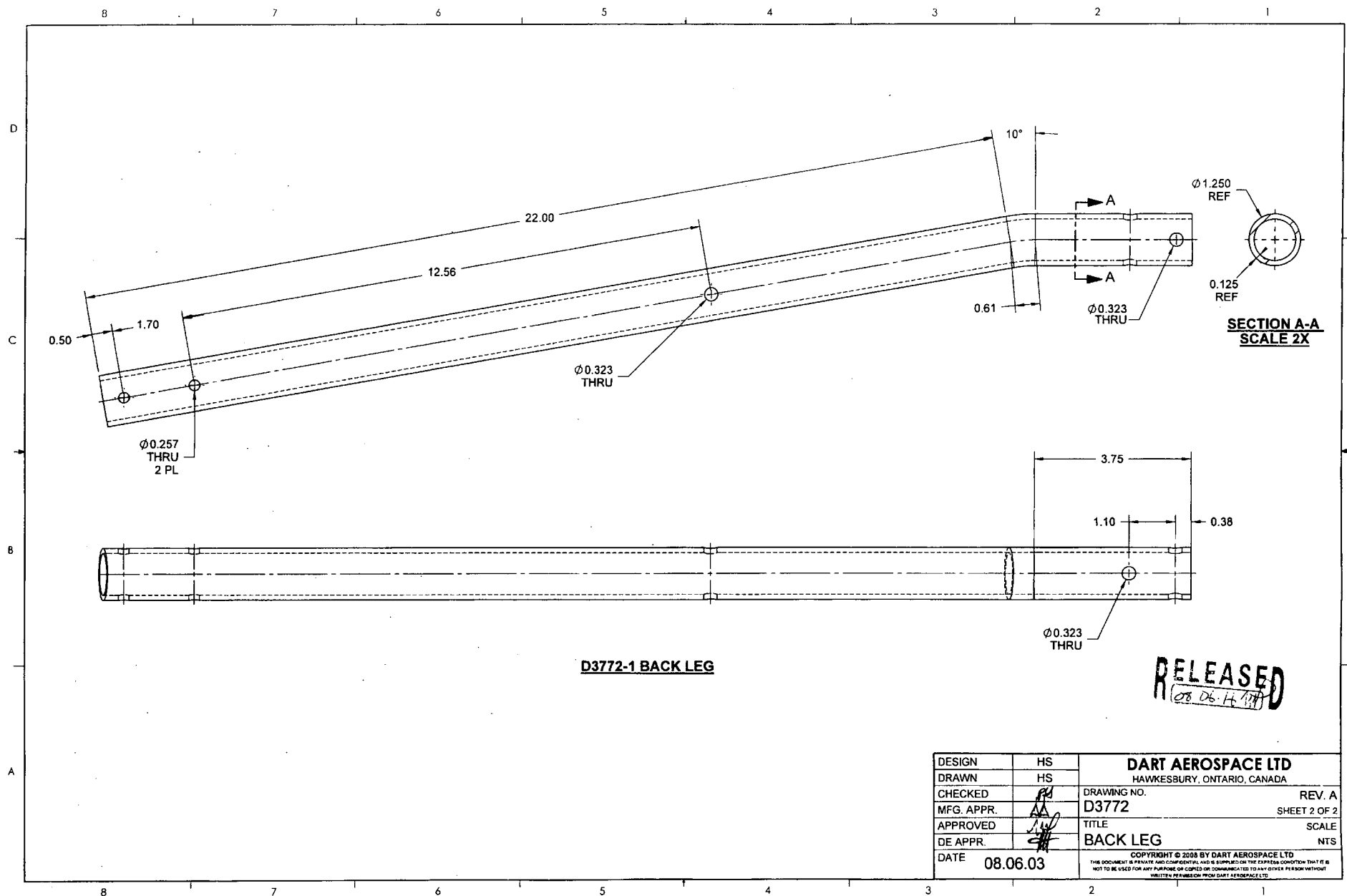
Rev	Date	Change	Revised by	Approved
A	08.10.17	New Issue	KJ/DD	
B	09.05.19	Dimensions 22.00 & 10° removed	KJ	



D3772-1 BACK LEG

- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.26 lbs

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO. D3772	REV. A
CHECKED	<i>[Signature]</i>	SHEET 1 OF 2	
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BACK LEG	NTS
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DRAWN	HS		
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MFG. APPR.	<i>[Signature]</i>	TITLE BACK LEG	SHEET 2 OF 2
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DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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